

Work Order ID 74784

74784

Page 1

October 6, 2011 11:37:21 AM

Item ID: D4034-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Upper Rib Assembly
 Start Date: 10/12/11 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 10/12/11 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/10 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	B								

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00

100

Large Fab

Large Fab

Memo

0.00

1- Assemble ribs to hoop and weld as per dwg DT9564 ✓

2- Weld bushing in rib as per dwg ✓

11/10/31 (3x)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

11.10.31

3x

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

11 10 31 (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	<i>Backed cell</i>								
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11/11/09 (3x)

11/11/14

11/11-11 (3)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

October 6, 2011 11:37:25 AM

Page 1

Work Order ID: 74784

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Parent Item: D4034-043

D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 10/12/11

Required Date: 10/12/11

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
PER DWG REV.B DD VERF:EC
IPP Rev:B as
IPP Rev:C 11.01.19 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4034-1 Rib		Manufactured	No			100	Each	3.0000	1	3			
------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		3							
				69014		3							

D4034-5 Rib		Manufactured	No			100	Each	5.0000	1	3			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				67339		1							
				72498		1							
				WA006		3							
				70343		3							

✓ D2327-3 Spacer Bushing		Manufactured	No			100	Each	24.0000	1	3			
-----------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		24							
				71971		1							
				72296		3							
				72963		20							

** B74780 → (3x) 10/10/27

** B74785 (1x) 11/10/27

2x (2x) 11/10/27

(3x)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

Page 2

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Work Order ID: 74784

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Parent Item: D4034-043

D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 10/12/11

Required Date: 10/12/11

Start Qty: 3.00

Required Qty: 3.00

D4021-7

Manufactured No

100

Each

10.0000

1

3

**

B 74807 → 2x *11/10/12*

✓ ***D4021-7***

Hoop

Location

Loc Qty

Loc Code

WA005

10

72252

10

(1x)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

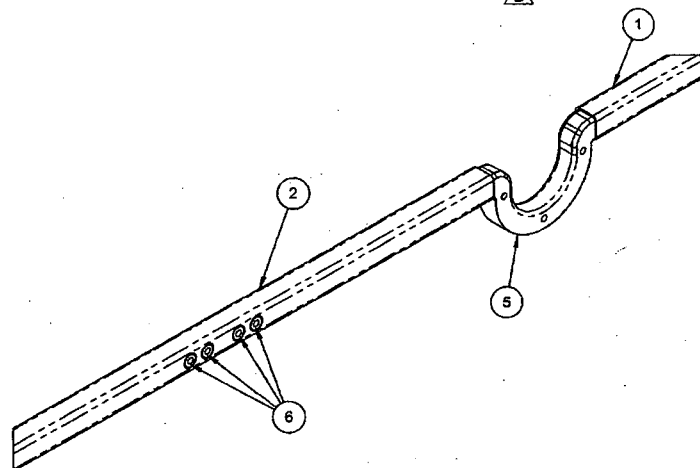
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

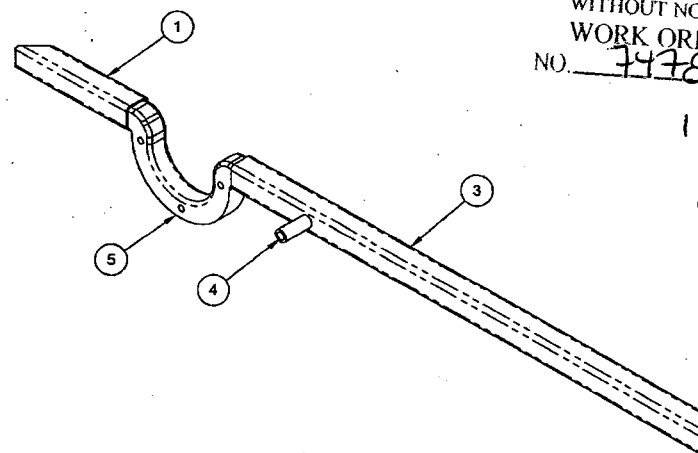
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 77784 M.L.J

11/10/06

RELEASED
R, 2011-01-18
M

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	R	DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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W/O:		WORK ORDER CHANGES					
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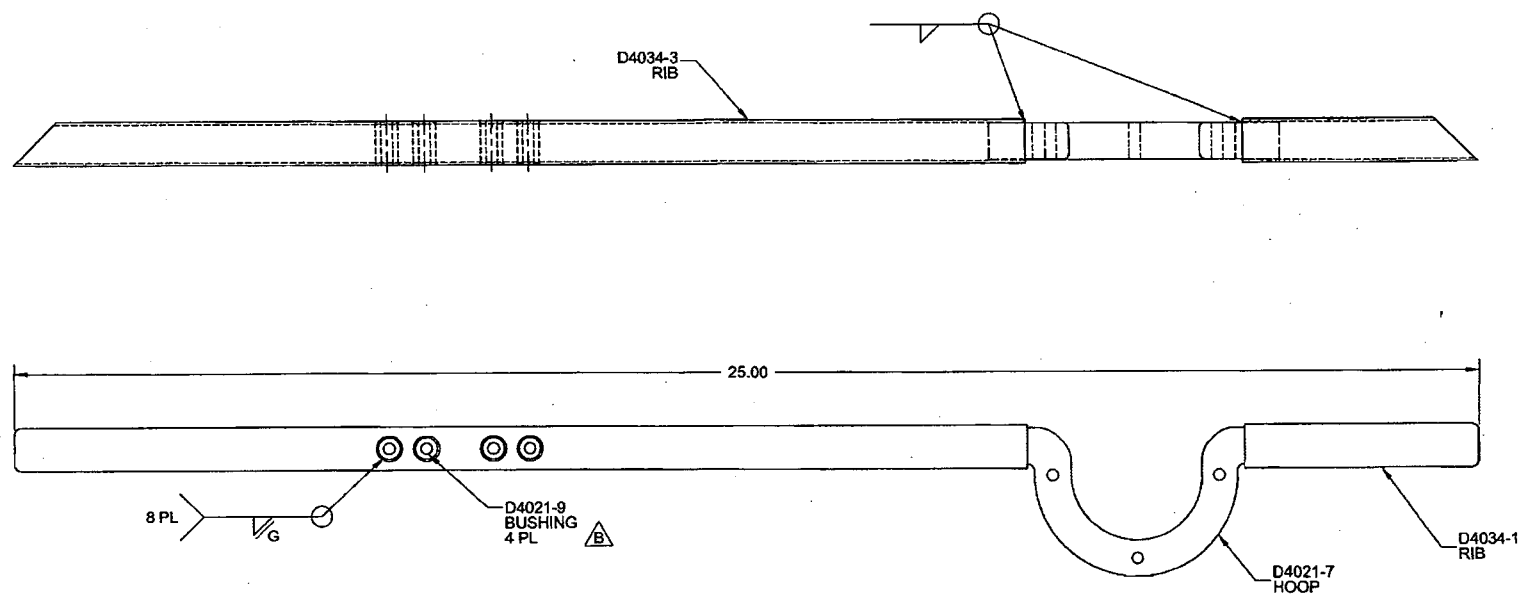
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**D4034-041 AFT UPPER RIB ASSY**

RELEASED
 2011-01-18
 NH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	AK	D4034	SHEET 2 OF 4
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	UPPER RIB ASSY, BASKET BASE	NTS
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W/O:		WORK ORDER CHANGES					
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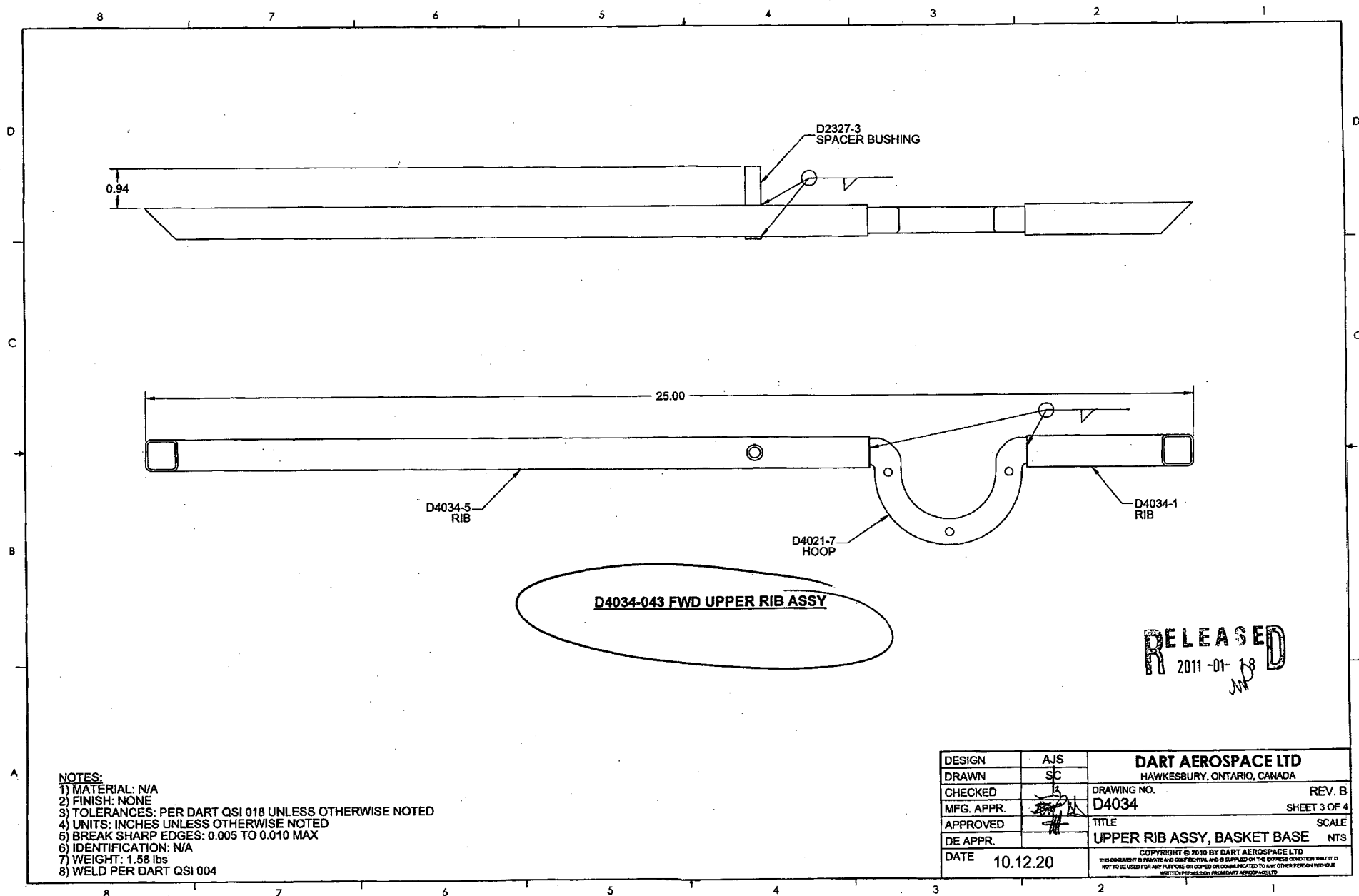
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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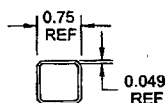
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

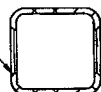
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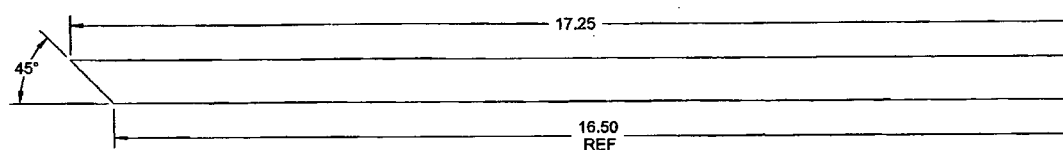
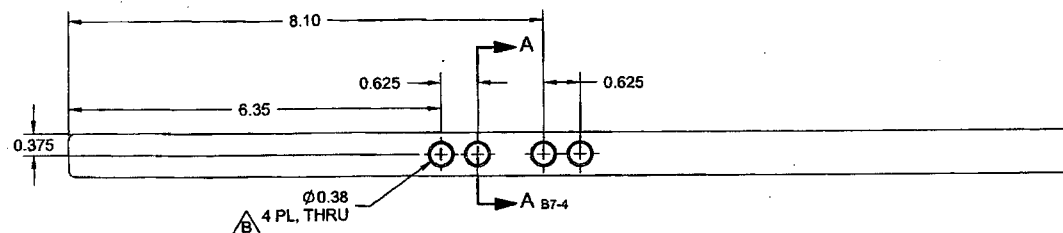
8	7	6	5	4	3	2	1
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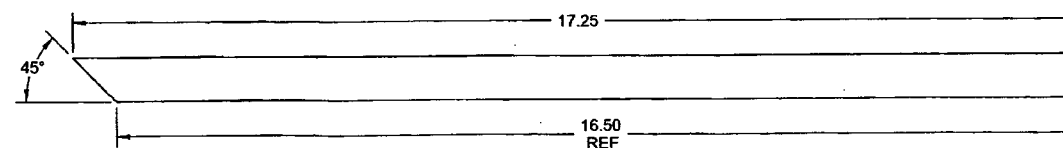
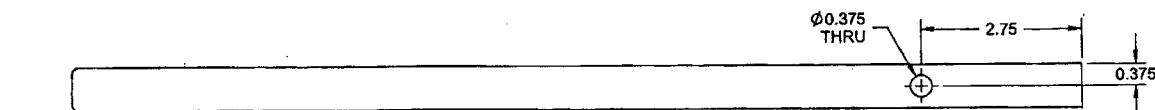
BREAK EDGE
0.030 X 45°
TYP.



SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB

RELEASED
2011-01-10

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.75W0.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESSBURG, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. F
MFG. APPR.	JS	D4034	SHEET 4 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	UPPER RIB ASSY, BASKET BASE	
DATE	10.12.20	NT	

Dart Aerospace Ltd

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